

Wednesday, June 07, 2017 1:45:47 PM

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Approvals: _____ **Process Plan:**  _____ **Date:** JUN 07 2017 **Tooling:** _____ **Date:** _____ **Run** **Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2161	Rev B2								

100		0.00	
100	Large Fab		
Large Fab		0.39	
Large Fab	Memo		
	1-Assemble on Jig DT8065 as per Dwg D21612-Weld as per Dwg D2161		
	Identify as D2161-204		

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

1

SEP 22 2017

DAS

24

9-89

120 QC5- Inspect part completeness to step on W/O 0.00
120
QC **Memo** 0.02
Quality Control

SEP 22 2017
DAS 24
9-89

DQA:

Date: Jan 4 2018

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date: JAN - 4 2018

Work Order update only ☐

Work Order: <u>156163</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																															
Part No. <u>B 2161-204</u>		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐																																																																									
NCR No. <u>17-6738</u>		Scrap ☒		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐																																																																									
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐																																																																									
		Suspected Unapproved ☐		Large Fab ☒		Composite ☐		Supplier ☐																																																																											
Date: <u>09/22/17</u>		Step #: <u>1.50</u>		QTY Effective: <u>①</u>				MRB (QS1042) Approval																																																																											
Description Work Order Deviation				Disposition				Completed By																																																																											
Found at inspection pcs WAS NOT PLACED At equal Distance.				SCRAP & REPLACE D2013-5 B <u>166395</u> D2013-6 B <u>B122877</u> D2037-101 B <u>163439</u>				S. H. Baker DYC 17/09/22																																																																											
								Lead hand / Supervisor Approval Verification																																																																											
								DAS SEP 21 2017 24 9-89																																																																											
								QC / QA Coordinator Approval																																																																											
								S. H. Baker																																																																											
Root Cause																																																																																			
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Work Order ID 156163

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Item ID: D2161-204 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mirror Bracket
Start Date: 6/12/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/21/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per OSI005 4.3 <i>M 136370</i> Memo START TIME: <i>1:00</i> OVEN TEMPERATURE: <i>229</i> FINISH TIME: <i>1:30</i>	0.00 0.12				<i>1</i>	<i>0</i>	<i>1709-22</i>	<i>DAS 9 9-89</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>1</i>	<i>0</i>	<i>SEP 2 2 2017</i>	<i>DAS 9 9-89</i>
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10				<i>1</i>	<i>6</i>	<i>SEP 2 5 2017</i>	<i>DAS 21 9-89</i>

DAS 21 9-89
SEP 2 5 2017

Picklist Print

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Work Order ID: 156163

156163

Parent Item: D2161-204

D2161-204

Parent Item Name: Mirror Bracket

Start Date: 6/12/2017

Required Date: 6/21/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 05-11-01 JLM
IPP Rev B: QC9, QC5 added at steps 5,6 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2013-5 *D2013-5* Mirror Bracket LH, 204		Manufactured	No			100	Each	3.0000	1	1			
									**			DYC 17/09/21	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA001 166395	3				1			
					128681	3				1			
D2013-6 *D2013-6* Mirror Bracket RH, 204		Manufactured	No			100	Each	1.0000	1	1			
									**			DYC 17/09/21	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA001 166396	1				1			
					122877	1				1			
D2037-101 *D2037-101* Arm		Manufactured	No			100	Each	4.0000	1	1			
									**			DYC 17/06/08	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA001	4							
					145478	1							
					158214	1							
					160006	2				1			



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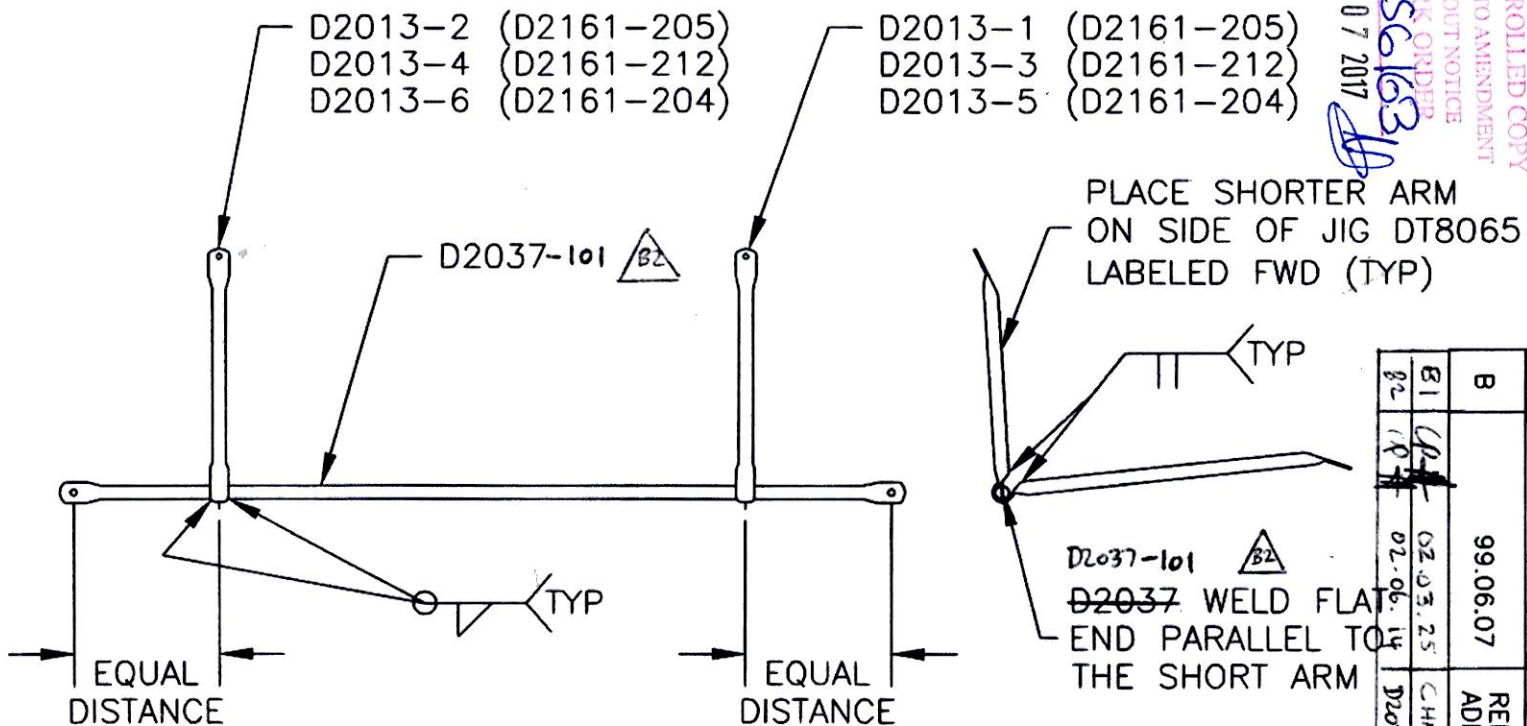
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 156163

JUN 07 2017



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NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
~~POWDER COAT BLACK SANDTEX (4.3.5.7) PER~~
~~DART QSI 005 4.3~~

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

DESIGN	JB	DRAWN BY	DART AEROSPACE LTD
CHECKED	KE	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	99.06.07	TITLE	MIRROR BRACKET
A	93.04.29	NEW ISSUE	REV. B
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	SHEET 1 OF 1
B1	02.03.25	CHANGE FINISH	SCALE
B2	02.06.14	D2037-101 W	NTS

RELEASED
KE 99.06.10